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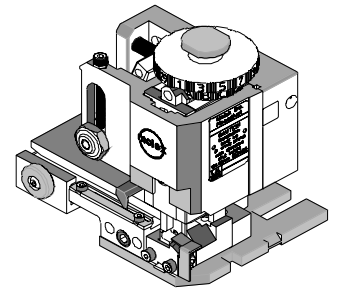
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63865-4000 Fine Adjust Applicator for MX150 Terminals



**FineAdjust Applicator  
Specification Sheet  
Part No. 63865-4000**



**FEATURES**

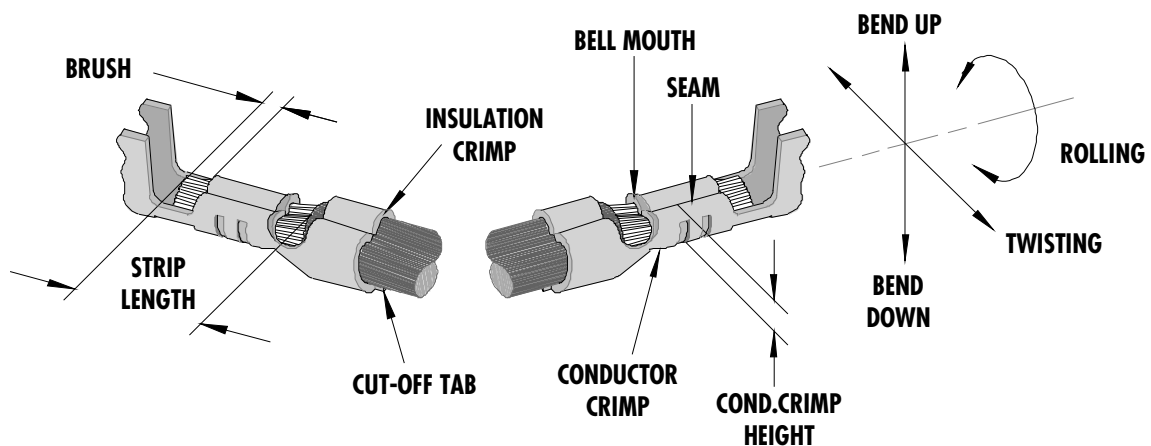
- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.15mm (.0006") for conductor crimp height and .063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other
- Directly adapts to most automatic wire processing machines

**SCOPE**

Terminal Series No.		Wire Size		Insulation Diameter		Strip Length	
		AWG	mm <sup>2</sup>	mm	In.	mm	In.
33000-1003	Male (tin)	22	0.36	1.50-1.65	.059-.065	4.70-5.60	.185-.220
33011-0006	Male (gold)	22	0.36	1.50-1.65	.059-.065	4.70-5.60	.185-.220
31296-0006	Male (long)	22	0.36	1.50-1.65	.059-.065	4.70-5.60	.185-.220

**Terminal will accommodate the following wire specification:**  
Wires to be thin wall thickness per Ford's specification MIL135-A1 and MIL123-A.

**DEFINITION OF TERMS**



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

63865-4000 Fine Adjust Applicator for MX150 Terminals

**CRIMP SPECIFICATION**

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
33000-1003	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
33011-0006	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026
31296-0006	0.25-1.25	.010-.049	0.50	.020	0.15-0.65	.006-.026

Terminal Series No.	Bend up Bend down		Twist	Roll	Punch Width mm (Ref)				Seam
	Degree				Degree		Conductor		
	mm	In	mm	In	mm	In	mm	In	
33000-1003	3	3	3	5	1.53	.060	1.85	.073	Seam shall not be open and no wire allowed out of the crimping area
33011-0006	3	3	3	5	1.53	060	1.85	.073	
31296-0006	3	3	3	5	1.53	060	1.85	.073	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
	AWG	mm <sup>2</sup>	Crimp Height		Crimp Width		Crimp Height		Crimp Width		N	Lb.
			mm	In.	mm	In.	mm	In.	mm	In.		
33000-1003	22	0.36	0.95-1.05	.037-.041	1.50-1.70	.059-.067	1.75-1.95	.069-.077	1.80-2.00	.071-.079	50.0	11.25
33011-0006	22	0.36	0.95-1.05	.037-.041	1.50-1.70	.059-.067	1.75-1.95	.069-.077	1.80-2.00	.071-.079	50.0	11.25
31296-0006	22	0.36	0.95-1.05	.037-.041	1.50-1.70	.059-.067	1.75-1.95	.069-.077	1.80-2.00	.071-.079	50.0	11.25

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

63865-4000 Fine Adjust Applicator for MX150 Terminals

**PARTS LIST**

Item	Order No	Engineering No.	Description	Quantity
	<b>63865-4000</b>	<b>63865-4000</b>	<b>FineAdjust Applicator (Fig. 1)</b>	<b>REF</b>
1	63457-0007	63457-0007	Conductor Punch	1 Y
2	63455-0009	63455-0009	Conductor Anvil	1 Y
3	63454-0014	63454-0014	Insulation Punch	1 Y
4	63456-0013	63456-0013	Insulation Anvil	1 Y
5	63461-0001	63461-0001	Cut-Off Plunger	1 Y
6	63443-0036	63443-0036	Front Plunger Retainer	1 Y
7	63700-0539	63700-0539	Cut-off Plunger Spring	1
8	63443-3160	63443-3160	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6004	63443-6004	Rear Cover	1
11	11-18-4094	60709A111	Front Cover	1
12	63443-2506	63443-2506	Anvil Mount	1
13	11-18-4080	60707-5	Wire Stop	1
14	63443-0009	63443-0009	Scrape Chute	1
15	63801-3100	63801-3100	Wide Track Fine Adjust Applicator Frame	1
16	63459-0001	63459-0001	* Wide Terminal Track	1
17	N/A	N/A	M3 by 6Lg. SHCS	2**
18	N/A	N/A	M4 by 6Lg. SHCS	1**
19	N/A	N/A	M4 by 12Lg. BHCS	2**
20	N/A	N/A	M4 by 50Lg. SHCS	2**
21	N/A	N/A	M5 by 12Lg SHCS	1**
22	N/A	N/A	3MM by 6Lg. Roll Pin	1**
23	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	<b>63865-4070</b>	<b>63865-4070</b>	<b>Tool Kit (All Y Items)</b>	<b>REF</b>

\* Frame Part to be Modified

\*\* The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

63865-4000 Fine Adjust Applicator for MX150 Terminals

**Assembly Drawing**

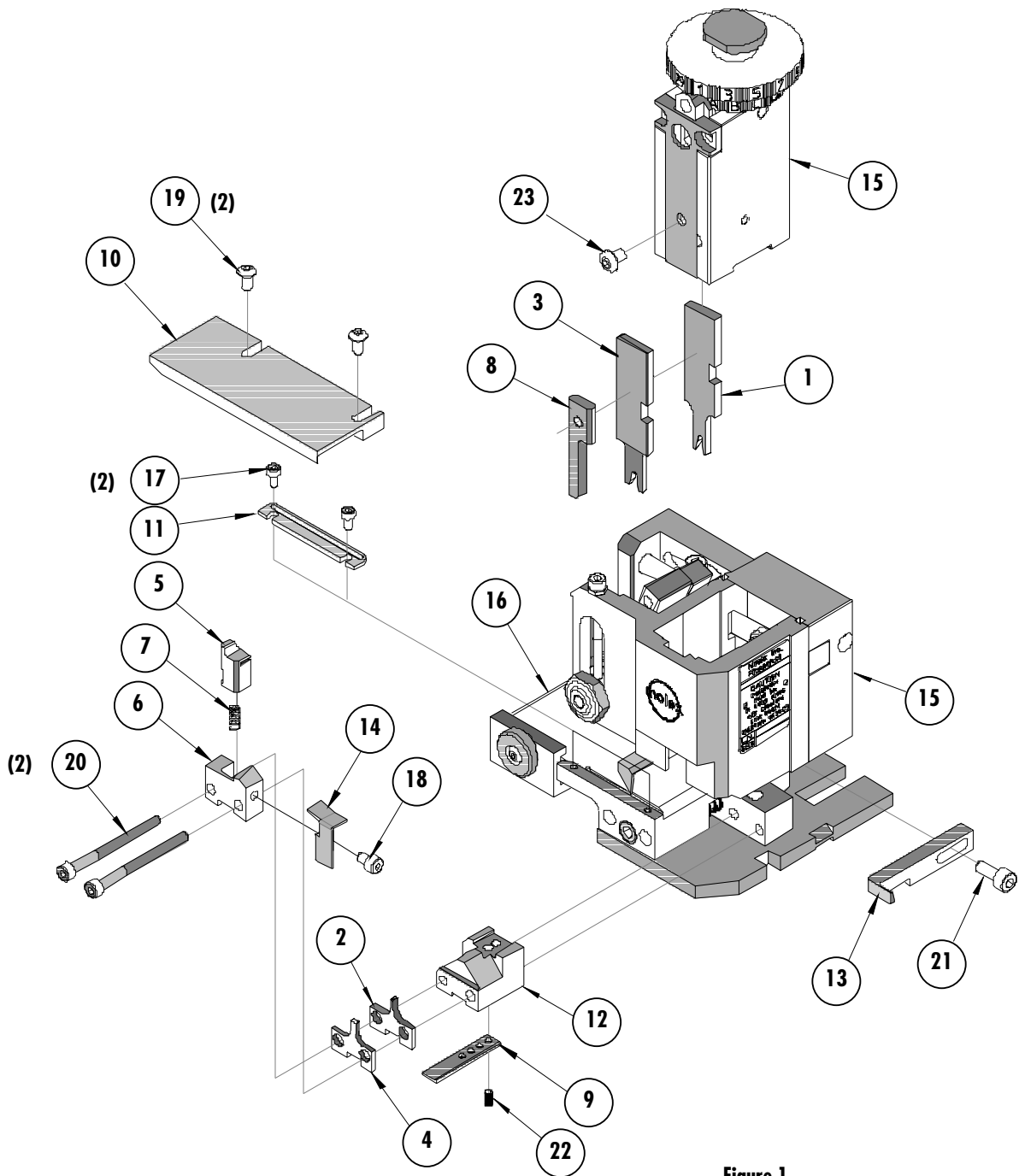


Figure 1

63865-4000 Fine Adjust Applicator for MX150 Terminals

## NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press and Applicator before crimping under power. Check that all screws are tight.
3. Slugs, Terminals, Dirt and Oil should be kept clear of work area.
4. Wear safety glasses at all times.
5. For recommended maintenance refer to the FineAdjust Manual.

**CAUTION:** This applicator should only be used in a press with a shut height of 135.8 mm (5.346"). Tooling damage could result at a lower setting.

**CAUTION:** To prevent injury never operate this Applicator without the guards supplied with the press or wire-processing machine in place. Reference the press or wire processing manufacturer's instruction manual.

**CAUTION:** Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

### Molex Application Tooling Group

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